

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2016-133 Date Opened: 07-Oct-16 Title: AssemblyAircraft OEM: Bell Aircraft Model: 429 Product Type: Cargo Basket Product Model: RH Post S/N 81 Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JC
N/A
JC
JC
JC
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JC
JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
95950	0	Basket Assembly	JC
95917	1	Lid Checker Plate	JC
95965	0	Fwd Sheet	JC
95916	1	Filler Sheet	JC
95927	1	Placard	JC
84240	0	Lid Brace Installation	JC
84255	2	Handle Installation	JC
84261	2	Handle Assembly	JC
36280	3	Lid Brace Assembly	JC

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
0
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Install checker plate on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

DB
DB
DB
DB
DB
DB
DB

Work performed by:

Print: D. Bartfai

Sign: 

SCA: AD07

Date: 12-Oct-16

ICC / Dual Inspection performed by:

Print: J. Clarke

Sign: 

SCA: AD02

Date: 12-Oct-16

Work Order closed by:

Print: J. Clarke

Sign: 

SCA: AD02

Date: 12-Oct-16

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC
V8A 0G3, 604-483-AERO (2376)

Quantity: 1
PN: MS20001P4-9600

Aircraft: All Model: All

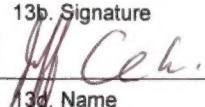
Description: Hinge

Supplier: Bisco Industries

Color: N/A

WO#: N/A

PO# 16030

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2016-0195	
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2016-133	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	Cargo Basket	95950-01-01	1	95911-04	New	
12. Remarks						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12. Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number AD 73-04 02		14b. Signature		14c. Approved Organization Number
13d. Name Jeff Clarke - AD02		13e. Date (dd/mm/yyyy) 12 Oct 2016		14d. Name		14e. Date (dd/mm/yyyy)
<p style="text-align: center;">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

Bell HELICOPTER

CARGO BASKET ASSEMBLY - COMMON

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket
94510, Revision 0 – Extra-Wide Low Mounted Basket
94610, Revision 0 – Extra-Wide Low Mounted Ski Basket
76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket
76410, Revision 3 – Medium Basket (left or right)
78410, Revision 2 – Long Basket
94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket
80310, Revision 0 – Medium Basket
81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2016-133

Date Open: 07 Oct 2016

AD
73-04
07

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

AD
73-04
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CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

AD
73-04
07

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

- d. Record PO of hinge and rivets on attached material tracking list.
4. Install Handle
- a. Install handle brackets.
- Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - Torque AN3 bolts to ??.
- b. Install handle
- Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - Grease two 36275-01 bushings with ???. Insert into bushings of handle assembly.
 - Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - At first end, remove bolt and repeat step iv.
 - Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - Torque AN3 bolts to ??.
- c. Check handle
- Operate handle to ensure handle does not bind and springs hold handle in.
 - Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.
5. Install lid brace
- Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
 - On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
 - On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
 - Ensure brace is seated on lip of bushings before tightening nuts.
 - Torque AN3 bolts to ??
 - Record PO/WO of all parts used in steps above on attached material tracking list.

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73-04
01

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

ND
73-04
02

6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

CARGO BASKET HANDLE FABRICATION

General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

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Complete
(initial or SCA #)

AD
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05

1. Weld Lever Assembly – handle lever jig required
 - a. Set MS20615-4M3 monel rivet into socket in jig
 - b. Set 36274-01 bushing into socket in jig
 - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
 - d. TIG weld around bushing using ER308L rod.
 - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
 - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
 - g. Record material POs on attached material list.

AD
73-04
07

2. Clean up
 - a. Clean lever assembly by media blasting with glass bead.
 - b. Drill out lever bushing to O (0.316) on lathe:
 - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
 - ii. Run at 300 RPM.
 - iii. Apply a drop of Rapid-Tap to drill.
 - c. De-burr.

AD
73-04
07

3. Fabricate Handle Assembly
 - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
 - b. Measure across TOP side of levers.
 - c. Cut handle tubing to length measured.
 - i. Handles under 40" long: 1.0" x 0.035 round tube
 - ii. Handles over 40" long: 1.0" x 0.065 round tube
 - d. De-burr tube.
 - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
 - f. Record material PO on attached material list.

AD
73-04
05

4. Weld Handle Assembly
 - a. Fuse tube to lever on both ends. Ensure levers are parallel.

5. Clean up
 - a. Clean welded area with scotch-brite.

AD
73-04
05

6. Final Inspection –

To be completed by a different person than the previous steps.

 - a. Welds for complete and handle for fit.
 - b. Tag complete and inspected parts in preparation for installation.

AD
73-04
02

Work Order: 2016-133

Material Tracking Sheet

1 of 2

Date Opened: 07 Oct 2016

Bell 429 - Post 81

Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			95950-01- 01	Cargo Basket Assembly	(-01 RH, -02 LH)	<i>5/N 95911-04</i>
Step 1				<i>Lid Assembly</i>		
Step 1.a.	. 1		95912-01-XX	Basket Lid Assembly		<i>2016-124</i>
	. . 4		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
	. . 1		95917-XX	Lid Checker Plate	3003 Aluminum Tread Plate, 0.063"	<i>14092</i>
	. . A/R		CR3213-4-02	Cherry Rivet		<i>15086</i>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		95951-01-XX	Basket Body Assembly		<i>2016-124</i>
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 8		NAS1149F0663P	Washer		
	. . 1		95965-01	Forward Sheet		<i>16003</i>
	. . 1		95916-03	Filler Sheet		<i>14092</i>
	. . 1		95927-01-XX	Placard	0.050 Sheet, 6061-T6 Aluminum	<i>2015-03</i>
	. . A/R		CR3213-4-02	Cherry Rivet		<i>15086</i>
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	95"	<i>16030</i>
	. 8		CR3523-5-02	Cherry Rivet		<i>15031</i>
	. A/R		CR3213-5-02	Cherry Rivet		<i>15086</i>
Step 4	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<i>2016-37</i>
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		

Work Order: 2016-133

Material Tracking Sheet

2 of 2

Date Opened: 07 OCT 2016

Bell 429 - Post 81

Basket Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		See attached
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	2016-132
	.. 2		AN3-12A	Bolt		
	.. 4		NAS1149F0363P	Washer		
	.. 2		MS21044N3	Nut		
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		16052
	. 1		AN3-15A	Bolt		
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
	. 2		MS21044N3	Nut		
Step 6				Inspection	None	

Work Order: 2016-133

Material Tracking Sheet

1 of 1

Date Opened: 07 OCT 2016

Bell 429 - Post 81

Handle Assembly

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1	84261	84261-01	Handle Assembly		
Step 1				Weld Lever Assembly		2015-122
	.2		84265-01	Lever	304 Stainless, 0.105 Sheet	
	.2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	.2		MS20615-4M3	Rivet		
	A/R		--	Welding Rod	ER308L TIG Rod	
Step 2				Clean Up	None	
Step 3				Fabricate Handle Bar		
	.1		36277-01	Handle Bar	304 Stainless, 1.0 x 0.065 Rnd. Tube	15073
Step 4				Weld Handle Assembly	None - Fuse weld, no rod req.	
Step 5				Clean Up	None	
Step 6				Inspection - Final Assembly	None	



Description: Basket Assembly Kit

WO#

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013



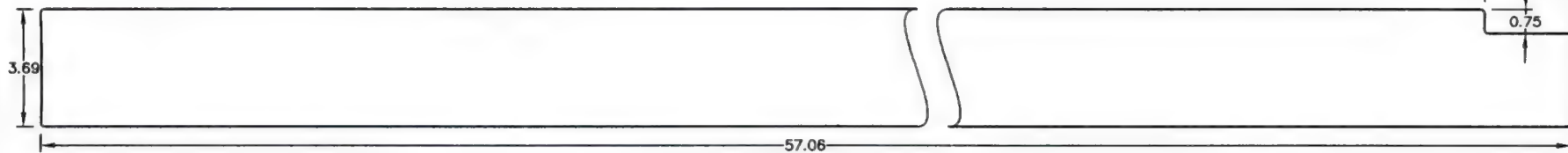
WO# _____

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; ADD SHEET 2	BJC	10/04/2014



① FORWARD FILLER SHEET

AS REQUIRED
TO SUIT RIVET
SPACING ON
BASKET HINGE
1.75 MIN




② AFT FILLER SHEET

AS REQUIRED
TO SUIT RIVET
SPACING ON
BASKET HINGE
1.0 MIN

1	95916-02	02	AFT FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET
1	95916-01	01	FORWARD FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALODINE, EPOXY PRIME AND POLYURETHANE PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.

NOTICE THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RESPONDENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.	APPROVALS DRAWN: JEFF CLARKE 09 NOV 2012 CHECKED: E. BURGAIN 10 NOV 2012		DATE		 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca		
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1					BELL 429 QUICK RELEASE CARGO BASKET FILLER SHEET	
	SCALE 1 : 4		DWG. SIZE DWG. NO.			REV.	
	SHEET 1 OF 2		LGL 95916			1	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK; ADD SHEET 2	BJC	10/04/2014



(03) FILLER SHEET


c/w dk

P0 14092

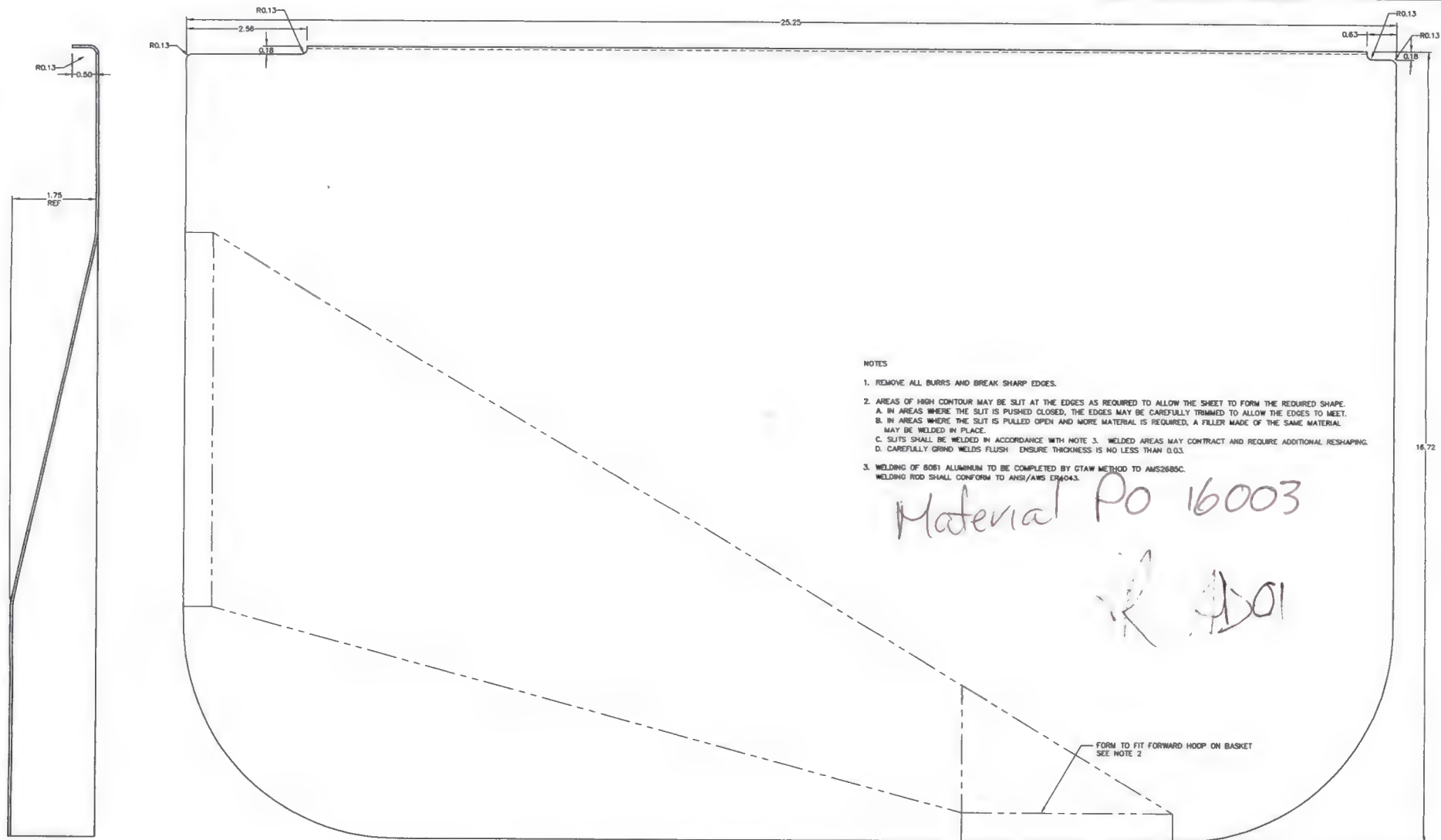
NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. THOROUGHLY DEGREASE, ALODINE, EPOXY PRIME AND POLYURETHANE PAINT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.
ALTERNATE: THOROUGHLY DEGREASE AND POWDER COAT ALL ALUMINUM PARTS PRIOR TO ASSEMBLY.

1	95916-03	01	FILLER SHEET	6061-T6 ALUMINUM	QQ-A-250/11	0.050" SHEET
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		
	BELL 429 QUICK RELEASE CARGO BASKET FILLER SHEET		
	SCALE 1 : 4 SHEET 2 OF 2	DWG. SIZE LGL	

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. AREAS OF HIGH CONTOUR MAY BE SLIT AT THE EDGES AS REQUIRED TO ALLOW THE SHEET TO FORM THE REQUIRED SHAPE.
 - A. IN AREAS WHERE THE SLIT IS PUSHED CLOSED, THE EDGES MAY BE CAREFULLY TRIMMED TO ALLOW THE EDGES TO MEET.
 - B. IN AREAS WHERE THE SLIT IS PULLED OPEN AND MORE MATERIAL IS REQUIRED, A FILLER MADE OF THE SAME MATERIAL MAY BE WELDED IN PLACE.
 - C. SLITS SHALL BE WELDED IN ACCORDANCE WITH NOTE 3. WELDED AREAS MAY CONTRACT AND REQUIRE ADDITIONAL RESHAPING.
 - D. CAREFULLY GRIND WELDS FLUSH. ENSURE THICKNESS IS NO LESS THAN 0.03.
3. WELDING OF 6061 ALUMINUM TO BE COMPLETED BY GTAW METHOD TO AWS2685C. WELDING ROD SHALL CONFORM TO AWS/AWS ER4043.

Material PO 16003

K ADO1

FORM TO FIT FORWARD HOOP ON BASKET
SEE NOTE 2

01 FORWARD SHEET
RH SHOWN, LH OPPOSITE

QTY	QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
		95965-02	01	FORWARD SHEET (LEFT HAND)	6061 ALUMINUM	QQ-A-250/11	0.050 SHEET
		95965-01	01	FORWARD SHEET (RIGHT HAND)	6061 ALUMINUM	QQ-A-250/11	0.050 SHEET
LIST OF MATERIALS							

APPROVALS		DATE	
DRAWN: JEFF CLARKE		10 APR 2014	
CHECKED: JASON REKVE			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:			
DECIMALS		ANGLES	
X.XXX ±0.010		±1/2°	
X.XX ±0.03			
X.X ±0.1			
SCALE 1 : 1		DWG. SIZE	
SHEET 1 OF 1		CNS. NO.	
		A1	
		95965	
		REV. 0	

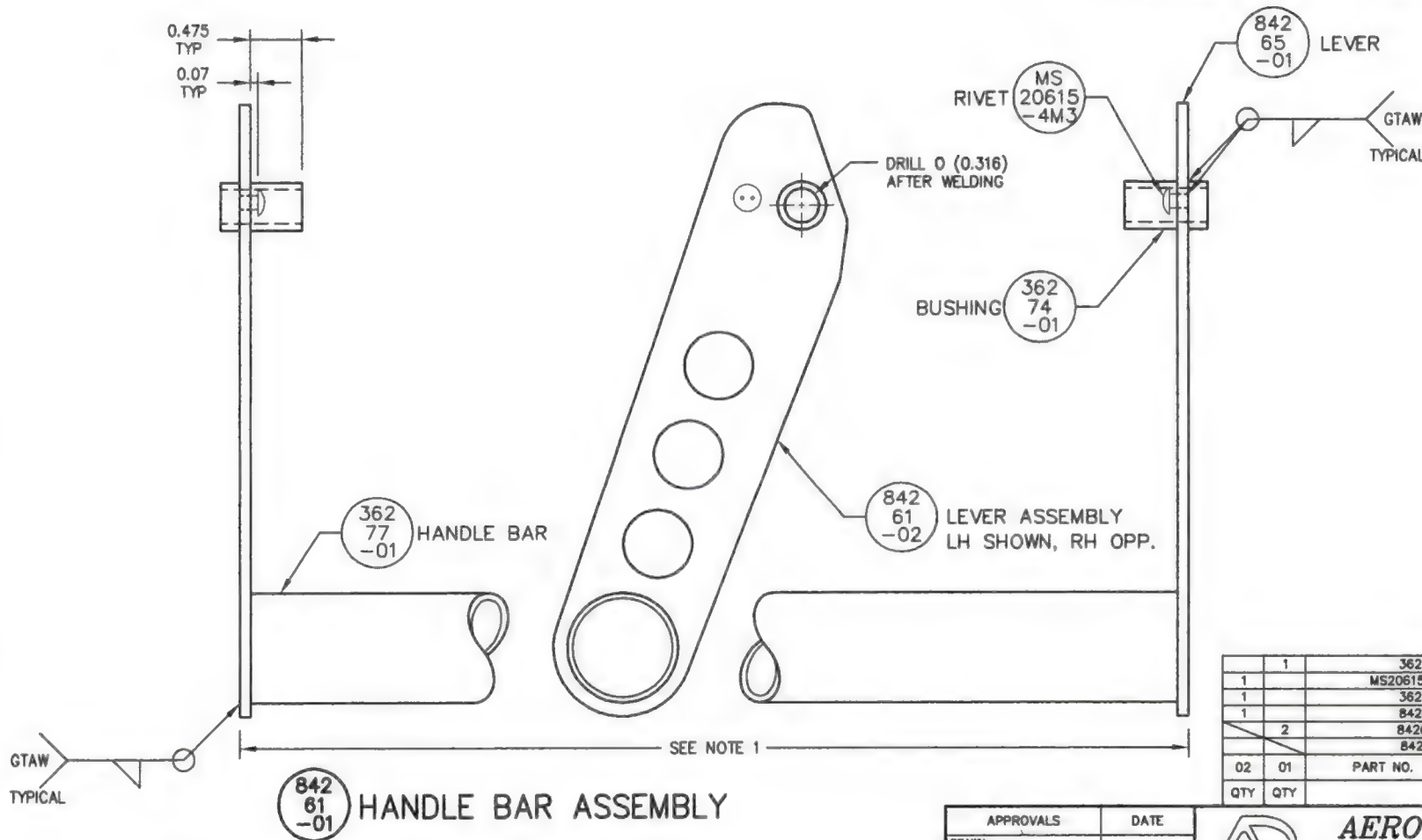


AERO DESIGN LTD.

9000A MALASPINA ROAD
POWELL RIVER, B.C. CANADA, V8A 0G5
TEL: 800-488-8278 WWW.AERODESIGN.CO

BELL 429 - S/N 57081 & SUB.
QUICK RELEASE CARGO BASKET
FORWARD SHEET

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1	1	36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
2		84261-02	LEVER ASSEMBLY (RH/LH)
		84261-01	HANDLE BAR ASSY
02	01		

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ±0.010 ±1/2°
X.XX ±0.03
X.X ±0.1



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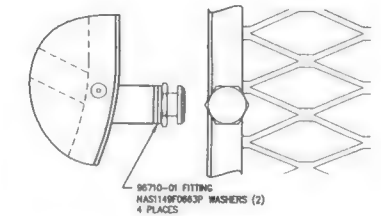
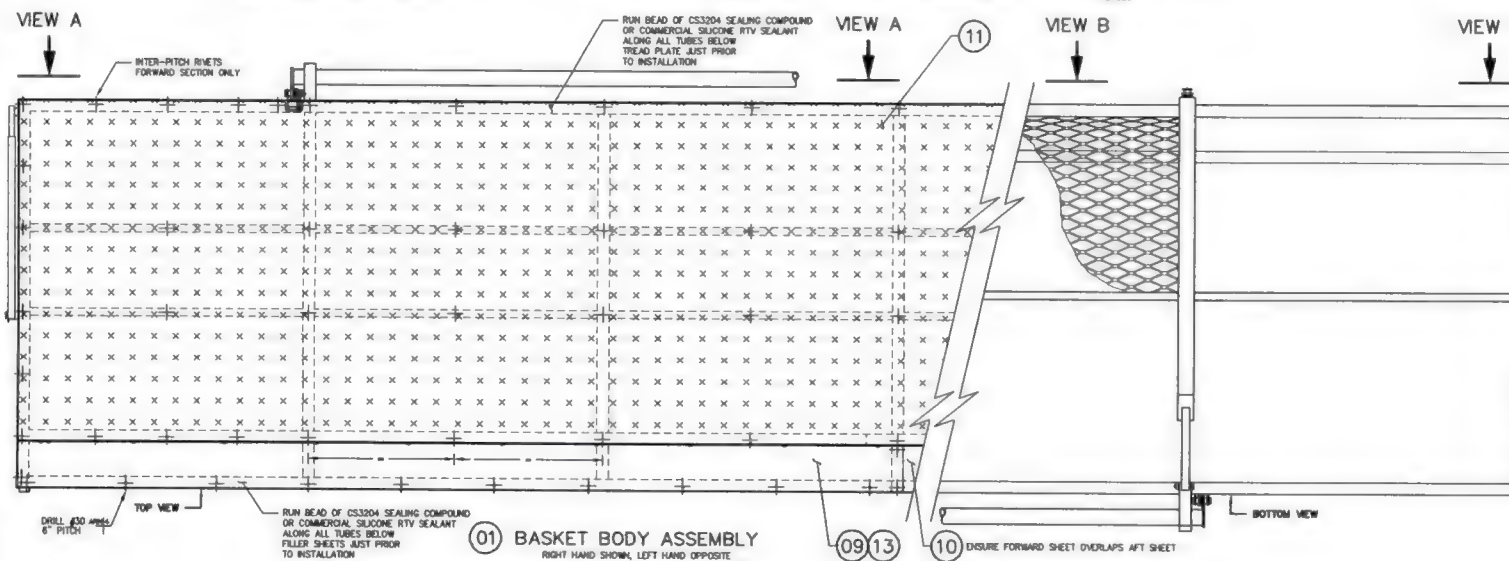
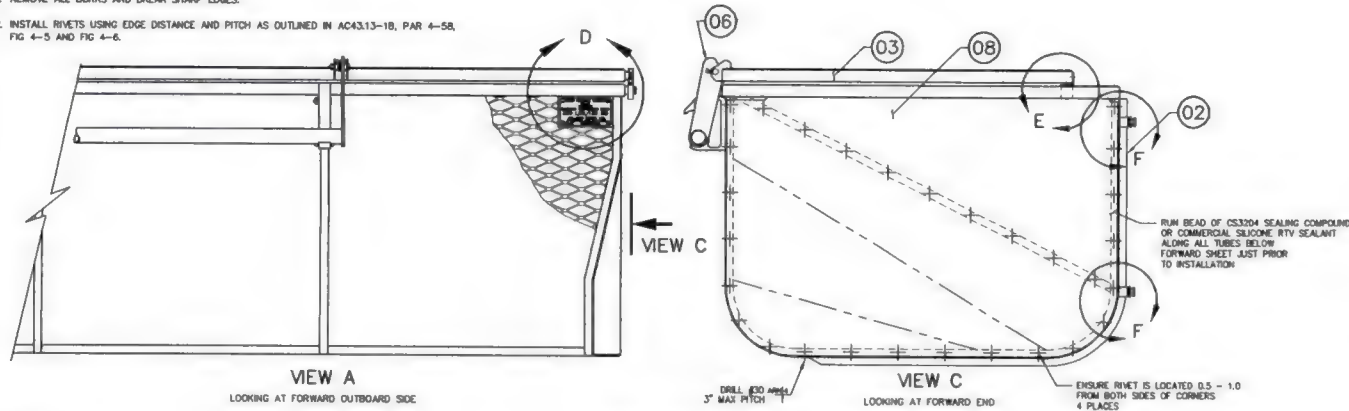
**HELICOPTER CARGO BASKET
HANDLE BAR ASSEMBLY**

SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84261	2
SHEET 1 OF 1			

NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. INSTALL RIVETS USING EDGE DISTANCE AND PITCH AS OUTLINED IN AC43.13-18, PAR 4-58, FIG 4-5 AND FIG 4-6.

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	CREATED FROM 95910, REV. 1		



DETAIL F

SCALE 1 : 1
LOOKING AT FORWARD LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR
REAR ATTACHMENTS SIMILAR

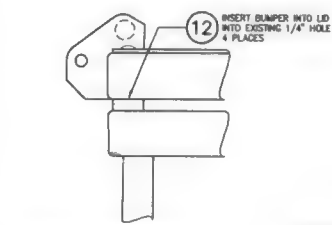
A/R/A/R	---	SILICONE SEALANT (CLEAR)	COMMERCIAL
A/R/A/R	CS3204	SEALING COMPOUND	AMS-5-BB02C T2 B1/2
0 5	WASHER		
4 6	90710-01	FITTING	ALT. ANORA 40088-14
A/R/A/R	CR3213-4-02	CHERRY RIVET	ALT. HR3213-4-02
8 8	CR3203-5-02	CHERRY RIVET	ALT. HR3203-5-02
A/R/A/R	CR3213-5-02	CHERRY RIVET	ALT. HR3213-5-02
A/R/A/R	95918-03	13 FILLER SHEET	ALTERNATE TO 09/10
4 4	49205-14	12 BUMPER	ARGUS INDUSTRIES
1 1	95917-02	11 LH LID CHECKER PLATE	
1 1	95917-01	11 RH LID CHECKER PLATE	
1 1	95916-02	10 AFT FILLER SHEET	
1 1	95916-01	09 FORWARD FILLER SHEET	
1 1	95905-02	08 LH FORWARD SHEET	
1 1	95905-01	08 RH FORWARD SHEET	
1 1	95927-04	07 LH PLACARD	
1 1	95927-03	07 RH PLACARD	
1 1	84255-01	06 HANDLE BAR INSTALLATION	
1 1	MS20001P4	05 PLANO HINGE	85" LONG
1 1	84240-01	04 LID BRACE INSTALLATION	
1 1	95912-01-02	03 LH LID ASSEMBLY	
1 1	95912-01-01	03 RH LID ASSEMBLY	
1 1	95951-01-02	02 RH BASKET BODY ASSEMBLY	
1 1	95951-01-01	02 LH BASKET BODY ASSEMBLY	
1 1	95950-01-02	01 LH CARGO BASKET ASSEMBLY	
1 1	95950-01-01	01 RH CARGO BASKET ASSEMBLY	
-02 -01	PART NO.	ITEM	DESCRIPTION
QTY	QTY		MATERIAL

LIST OF MATERIALS

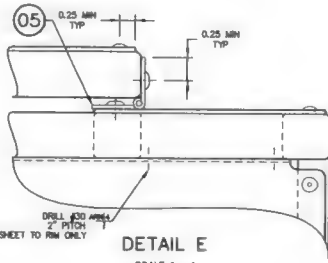
APPROVALS	DATE
DRAWN: JEFF CLARKE	20 FEB 2014
CHECKED: JASON REKVE	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	ANGLES
DECIMALS X.XXX ±0.010 X.XX ±0.03 X.X ±0.1	±1/2°

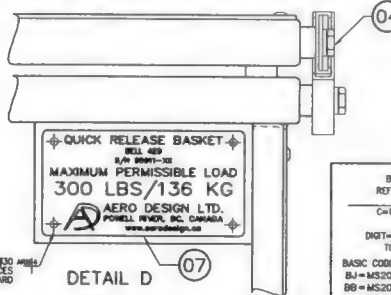
SCALE 1 : 4	DWG. NO.	REV.
SHEET 1 OF 1	A1	95950



BUMPER INSTALLATION
SCALE 1 : 1



DETAIL E
SCALE 1 : 1
LOOKING AT HINGE



DETAIL D
SCALE 1 : 1
LOOKING AT PLACARD BRACKET

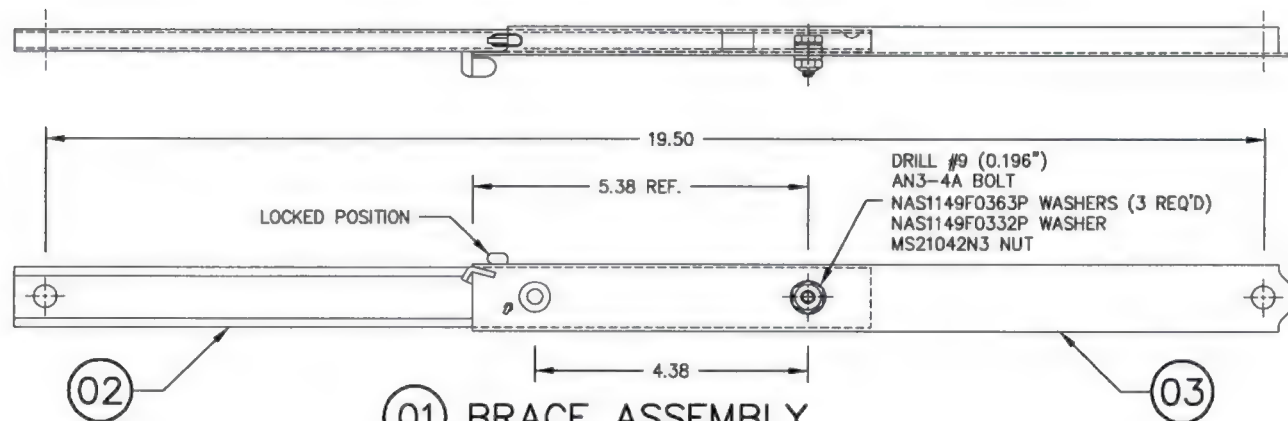
BASIC CODE	DASH NO. FOR DIAMETER	APPROVALS	DATE
REF. HAS 323	A=MFD. HEAD NEAR SIDE F=MFD. HEAD FAR SIDE	DRAWN: JEFF CLARKE	20 FEB 2014
C=COUNTERSUNK D=DIMPLE DIGIT# OF SHEETS TO BE DIMPLED	DASH NO. FOR LENGTH	CHECKED: JASON REKVE	
BASIC CODES: BJ=MS20470AD BB=MS20426AD ARH=CR3213 ATM=CR3523	+ INSTALL NEW RIVET + REMOVE/REPLACE RIVET - EXISTING RIVET	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED POSITION OF STOP BOLT (WAS 4.38")	STF	JUL 01/02
2	CHANGED POSITION OF STOP BOLT (WAS 4.31")	BJC	APR 28/04
3	TITLE BLOCK UPDATED; COMPONENT PARTS IDENTIFIED	BJC	13/03/2014



EXTENDED



01 BRACE ASSEMBLY

REMOVE SLIDER TO PERFORM MODIFICATION

1	MS21044N3		NUT	
1	NAS1149F0332P		WASHER	
3	NAS1149F0363P		WASHER	
1	AN3-4A		BOLT	
1	36280-03	03	MODIFIED GUIDE	STOCK: 9-2081 PROP
1	36280-02	02	MODIFIED SLIDER	VICTORIA BRITISH
	36280-01	01	BRACE ASSEMBLY	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY	LIST OF MATERIALS			

APPROVALS	DATE
DRAWN: STEVEN FAHEY	MAR 18/02
CHECKED: E. BURGOIN	MAY 01/03

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ± 0.010 $\pm 1/2^\circ$
X.XX ± 0.03
X.X ± 0.1

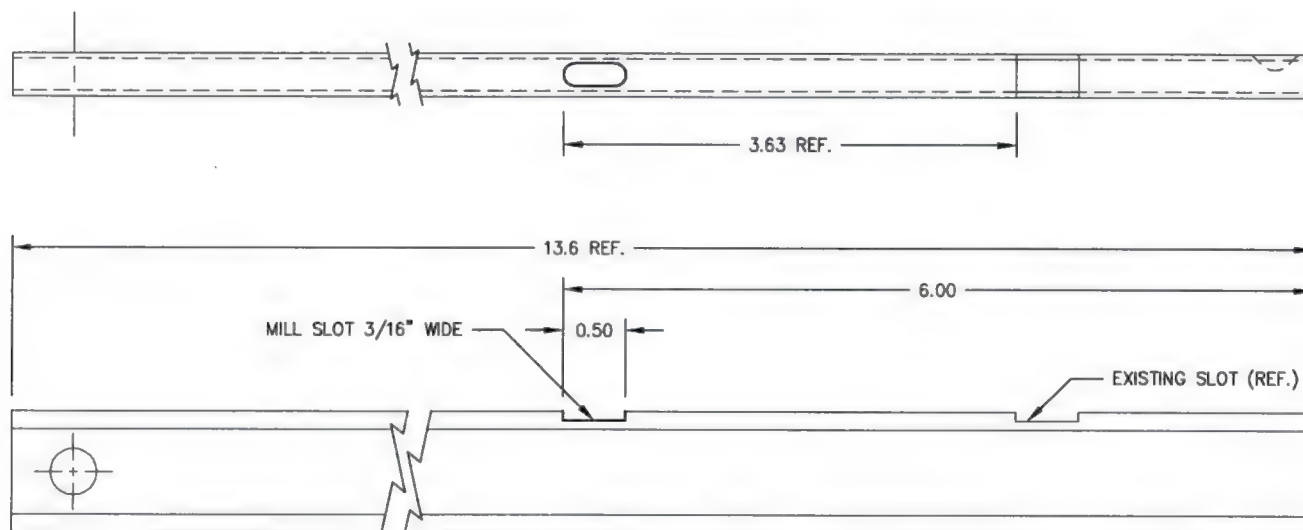


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POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 804.483.2376 www.aerodesign.ca

HELICOPTER CARGO BASKET
LID BRACE ASSEMBLY

SCALE 1 : 2	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 2	A3	36280	3



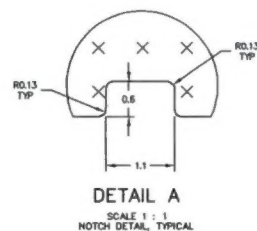
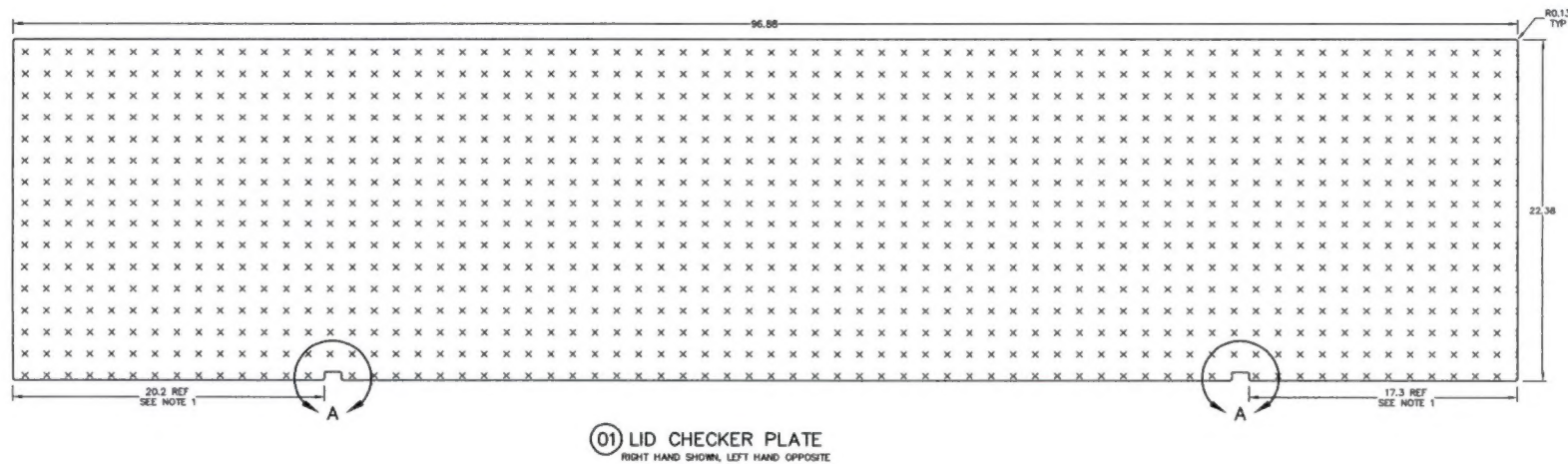
02 MODIFIED SLIDER

REMOVE FROM GUIDE TO PERFORM MODIFICATION

1	9-2081		LID BRACE	VICTORIA BRITISH
	36280-02	02	MODIFIED SLIDER	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			


APPROVALS	DATE	 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca			
DRAWN: STEVEN FAHEY	MAR 18/02				
CHECKED: E. BURGOIN	MAY 01/03				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		HELICOPTER CARGO BASKET LID BRACE SLIDER MODIFICATION			
SCALE 1 : 2		DWG. SIZE	DWG. NO.	REV.	
SHEET 2 OF 2		A3	36280	3	

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	UPDATE TITLE BLOCK	BJC	10/04/2014



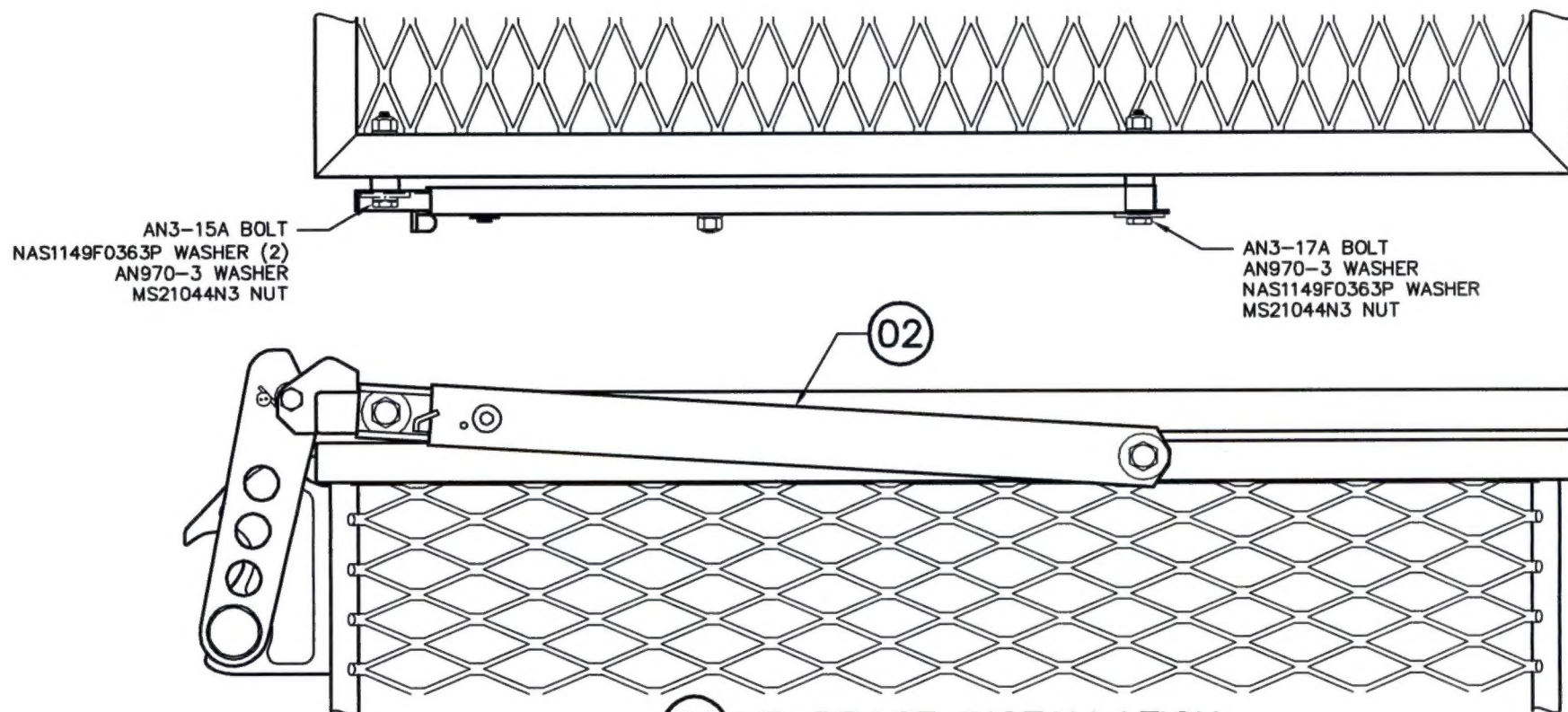
NOTES

1. LOCATION OF NOTCHES TO FIT LID ASSEMBLY 95912-01.
2. REMOVE ALL BURRS AND BREAK SHARP EDGES.

1	95917-02	01	LH LID CHECKER PLATE	3003 ALUMINUM	COMMERCIAL	0.063" C-102 CHECKER
1	95917-01	01	RH LID CHECKER PLATE	3003 ALUMINUM	COMMERCIAL	0.063" C-102 CHECKER
QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
LIST OF MATERIALS						
APPROVALS				DATE		
DRAWN: JEFF CLARKE				09 NOV 2012		
CHECKED: E. BURDORF				10 NOV 2012		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:						
DECIMALS				ANGLES		
X.XXX ±0.010				±1/2°		
X.XX ±0.03						
X.X ±0.1						
				AERO DESIGN LTD.		
				9508A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8B 0G3 TEL: 804-480-2276 www.aerodesign.ca		
BELL 429 QUICK RELEASE CARGO BASKET LID CHECKER PLATE FABRICATION						
SCALE 1 : 4				DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1				A1	95917	1

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



(01) LID BRACE INSTALLATION

NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

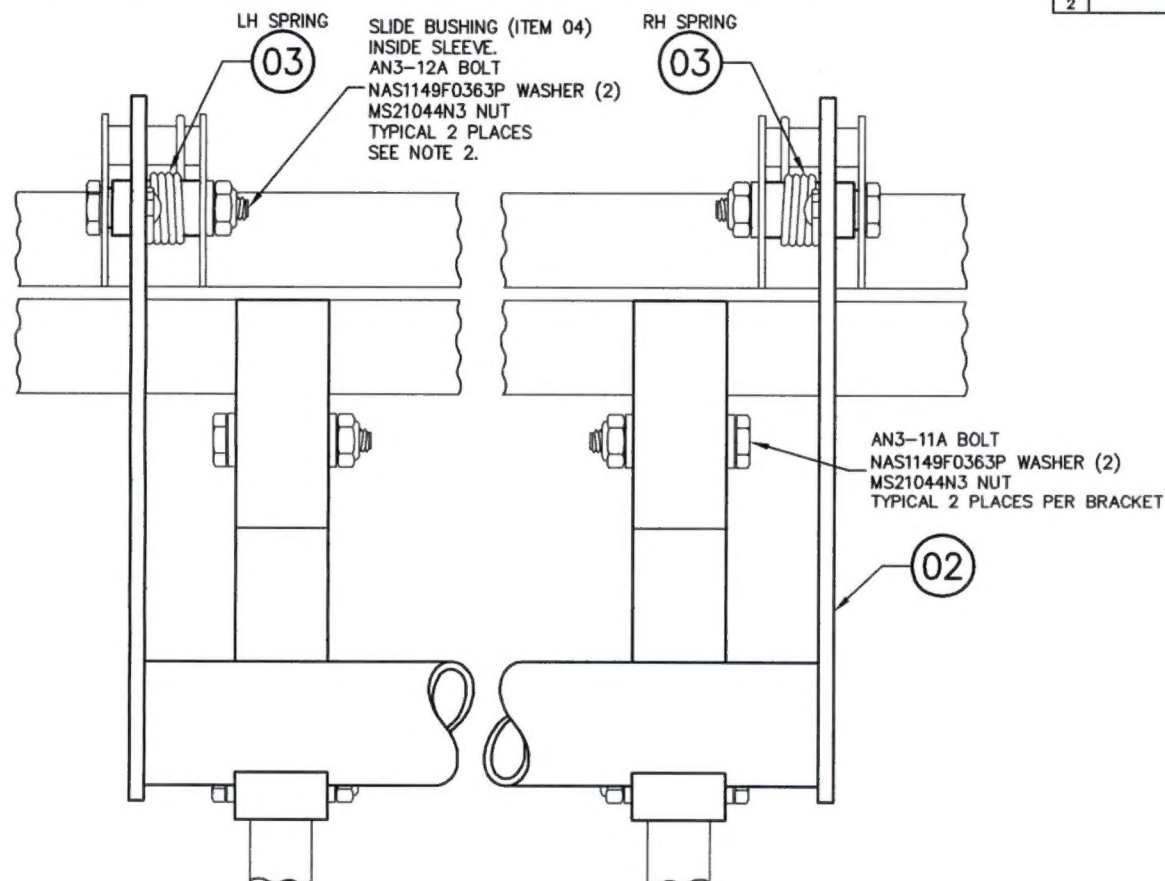
2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

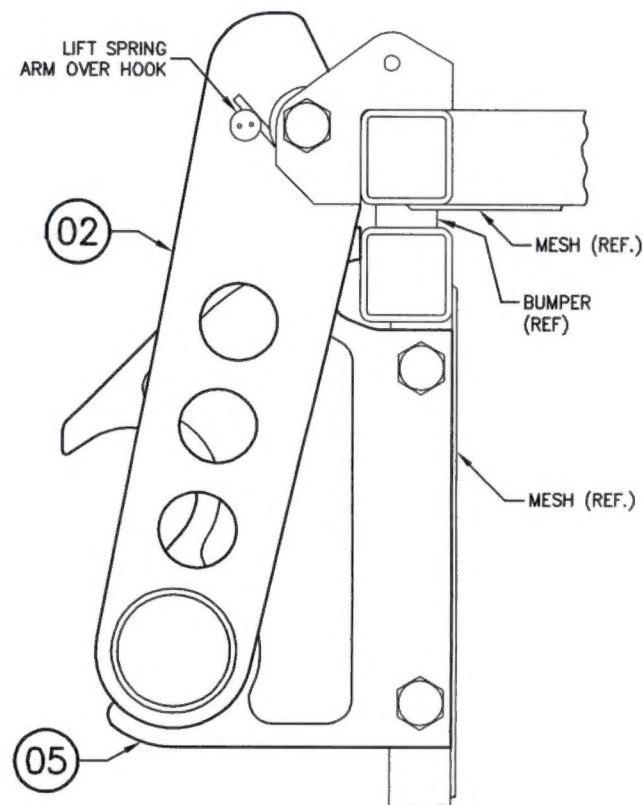
	AERO DESIGN LTD.		
	9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.463.2376 www.aerodesign.ca		
HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION			
NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



01 HANDLE INSTALLATION



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

A/R	MOBILGREASE 28		GREASE	MIL-PRF-81322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

APPROVALS	DATE
DRAWN: JEFF CLARKE	03 NOV 2009
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES.
TOLERANCES ON:
DECIMALS ANGLES
X.XXX ± 0.010 $\pm 1/2^\circ$
X.XX ± 0.03
X.X ± 0.1



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POWELL RIVER, BC, CANADA, V8A 0G3
TEL: 604.483.2376 www.aerodesign.ca

**HELICOPTER CARGO BASKET
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2

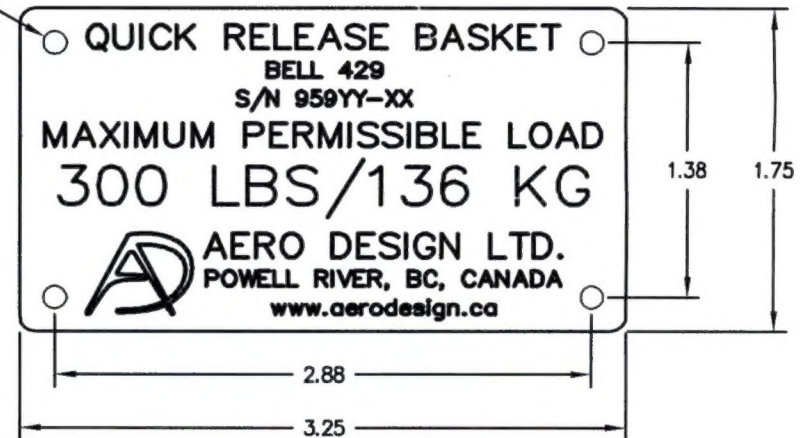
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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED; ADDRESS, LOGO AND S/N UPDATED	BJC	11/03/2014

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
 "QUICK RELEASE BASKET" - 0.125 HIGH
 "BELL 429" - 0.080 HIGH
 "S/N 959YY-XX" - 0.080 HIGH - (SEE NOTES 2-5)
 "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
 "300 LBS. TOTAL" - 0.200 HIGH
 "AERO DESIGN LTD." - 0.125 HIGH
 "POWELL RIVER, BC, CANADA" - 0.080 HIGH
 "www.aerodesign.ca" - 0.080 HIGH
- ITEM 01: RH BASKET FOR A/C S/N THRU 57080, S/N TO READ:
 "S/N 95901-XX" - 0.080 HIGH
- ITEM 02: LH BASKET FOR A/C S/N THRU 57080, S/N TO READ:
 "S/N 95902-XX" - 0.080 HIGH
- ITEM 03: RH BASKET FOR A/C S/N 57081 AND SUB, S/N TO READ:
 "S/N 95911-XX" - 0.080 HIGH
- ITEM 04: LH BASKET FOR A/C S/N 57081 AND SUB, S/N TO READ:
 "S/N 95912-XX" - 0.080 HIGH


DRILL #30 (0.129)
4 PLACES



01 02 03 04 PLACARD

1	95927-04	04	LH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
1	95927-03	03	RH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
1	95927-02	02	LH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
1	95927-01	01	RH PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.050 SHEET
	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

QTY	LIST OF MATERIALS
-----	-------------------

	APPROVALS	DATE	 <div>AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca</div>			
	DRAWN: JEFF CLARKE	11 SEPT 2012				
	CHECKED: E. BURGOIN	10 NOV 2012				
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1					
			BELL 429 QUICK RELEASE CARGO BASKET PLACARD			
SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.		
SHEET 1 OF 1		A1	95927	1		